

Work Order ID 88947

88947

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Saturday, August 11, 2012 12:38:24 PM

Item ID: D3637-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 8/13/2012 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 8/24/2012 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/08/13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3637	Rev B					18			

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary

304.686

182-8-16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

182-8-16

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00 2.8.16

Quality Control

SmB

DAS
16
2-29

2/06/17

18

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Item ID: D3637-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket Assembly

Stop ***NS2***

Start Date: 8/13/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3637

0.00

0.00

18

8/26/12

PTO

140

140

Small Fab

Small Fab

Small Fab

Memo

1- drill holes as per dwg using DT89792-C Sink as per Dwg D3637 3-
Install Nut plate as per Dwg D3637

0.00

0.00

17x

8/26/12

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Smb
12-9-18

DAS
16
8/16/18

17

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *AW*Date: *12/09/18*QA Closed: *CK*Date: *12/9/18*

Work Order: <u>88947</u> Part No. <u>DB637-041</u> NCR No. <u>12-1823</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input checked="" type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
---	--	--	--	--	--	--	--	--	--	--	--

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input checked="" type="checkbox"/>	12/01/18	140	1	1 part moved & was out of tolerance when drilling. 0.191" hds. bc better tooling is needed. <i>Re process</i>	DAS 15 2-83 057042 12/6/18	Scrap destroy \$30.06	<i>[Signature]</i> 12/09/18	SB 12/09/18	DAS 15 2-83 057042 12/09/18
Equip/Tooling <input checked="" type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input checked="" type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input checked="" type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input checked="" type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other <i>Better tooling is needed when drilling hds.</i>

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Start Date: 8/13/2012 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 8/24/2012 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location ST245A	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

10x **SP**
12-9-18

12/9/19

MP
12-09-17

Picklist Print

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Work Order ID: 88947

Parent Item: D3637-041

Parent Item Name: Bracket Assembly

Start Date: 8/13/2012

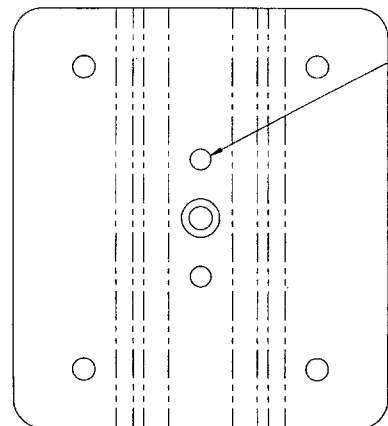
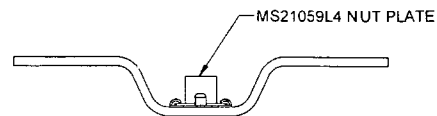
Required Date: 8/24/2012

Start Qty: 16.00

Required Qty: 16.00

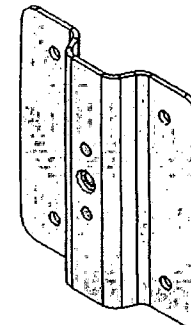
Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 Rivet		Purchased	No			100	Each	2,363.0000	2	32		8/12/08/30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		2363							
				119109		382							
				121011		1564							
				19099		417							
M304S14GA 304SS sheet .080		Purchased	No			140	sf	68.1400	0.09	1.5157895		8/12-8-16	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		68.14							
				117933		3.6							
				119276		64.54							
MS21059L4 Nutplate		Purchased	No			140	Each	57.0000	1	16		8/12/08/30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				315		49							
				122441		49							
				ST301		8							
				117887		3							
				119623		5							



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 88943 MCT
12/08/13

**D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)**

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637-1, 1.15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE, REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	TS		
CHECKED	TS		
MFG. APPR.	TS		
APPROVED	TS		
DE APPR.	TS		
DATE	07.12.18		

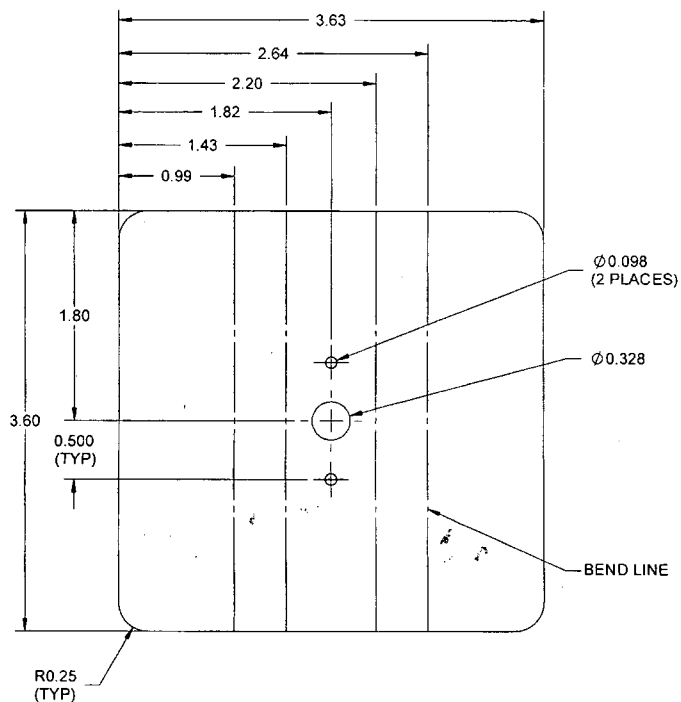
RELEASED
12/08/13

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

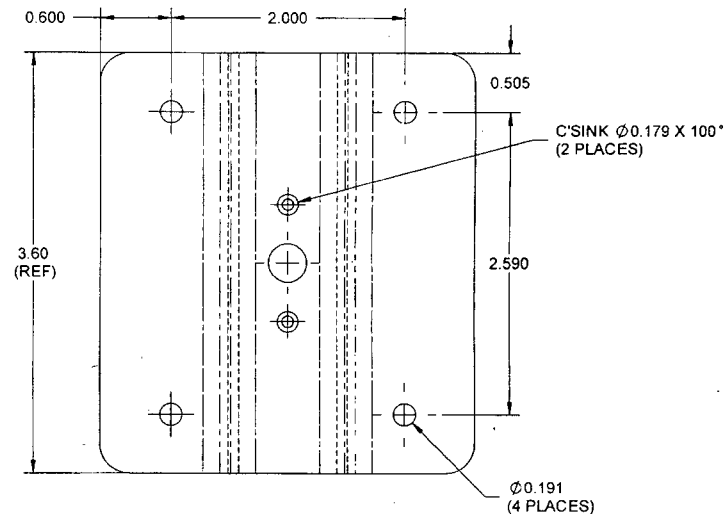
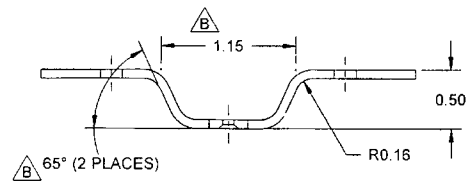
DRAWING NO. **D3637** REV. B
SHEET 1 OF 3
TITLE **BRACKET** SCALE 1:1

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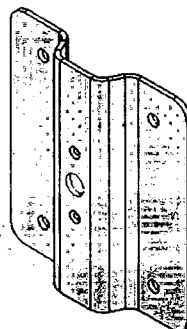
28947



D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



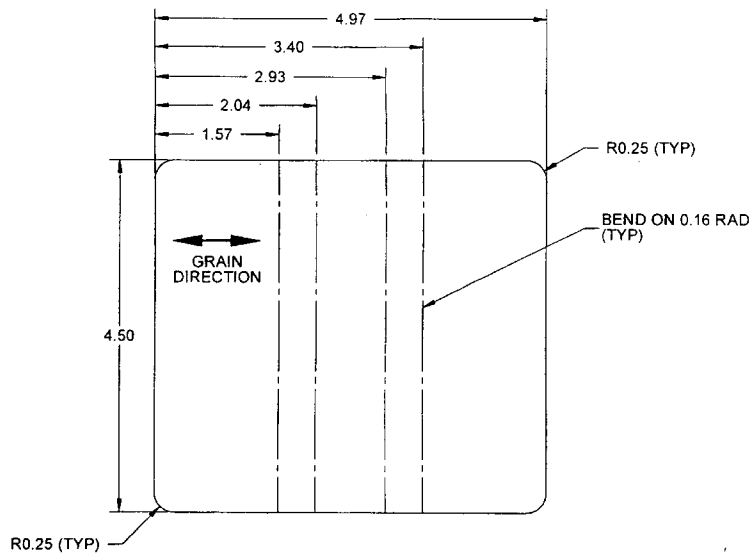
D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

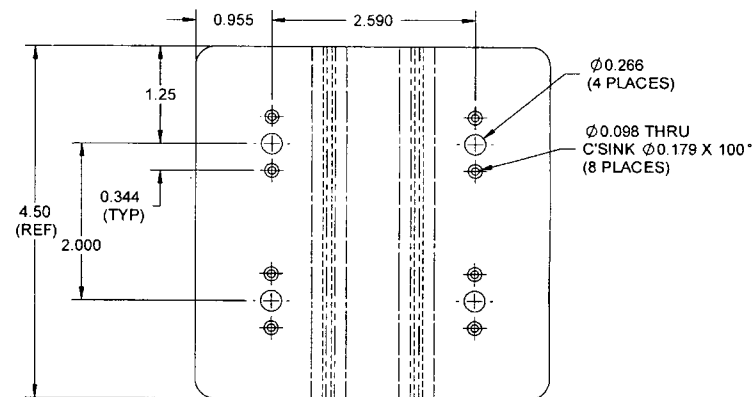
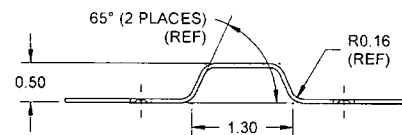
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W	DRAWING NO.	REV. B
MFG. APPR.	W	D3637	SHEET 2 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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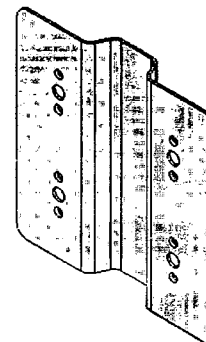
28947



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PE	DRAWING NO.	REV. B
MFG. APPR.	ED	D3637	SHEET 3 OF 3
APPROVED	MT	TITLE	SCALE
DE APPR.	MT	BRACKET	2:3
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